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(54) **TEXTURED ENCAPSULANT SURFACE IN LED PACKAGES**

(75) Inventors: **Ban P. Loh**, Durham, NC (US);
Chenhua You, Cary, NC (US); **Bernd Keller**, Santa Barbara, CA (US);
Nathaniel O. Cannon, Morrisville, NC (US); **Mitch Jackson**, Raleigh, NC (US); **Ernest W. Combs**, Raleigh, NC (US)

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(73) Assignee: **CREE, INC.**, Goleta, CA (US)

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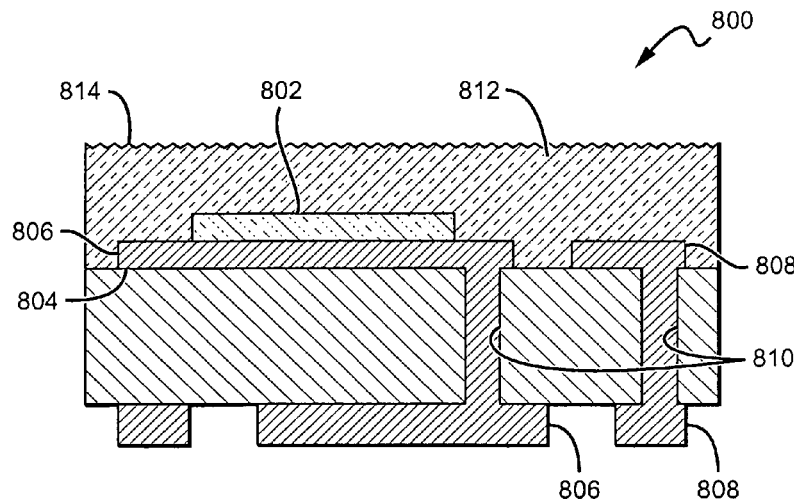
(74) *Attorney, Agent, or Firm* — Koppel, Patrick, Heybl & Philpott

(57)

ABSTRACT

A packaged LED device having a textured encapsulant that is conformal with a mount surface on which at least one LED chip is disposed. The textured encapsulant, which can be textured using an additive or subtractive process, is applied to the LED either prior to or during packaging. The encapsulant includes at least one textured surface from which light is emitted. The textured surface helps to reduce total internal reflection within the encapsulant, improving the extraction efficiency and the color temperature uniformity of the output profile. Several chips can be mounted beneath a single textured encapsulant. A mold having irregular surfaces can be used to form multiple encapsulants over many LEDs simultaneously.

28 Claims, 3 Drawing Sheets



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* cited by examiner

FIG. 1

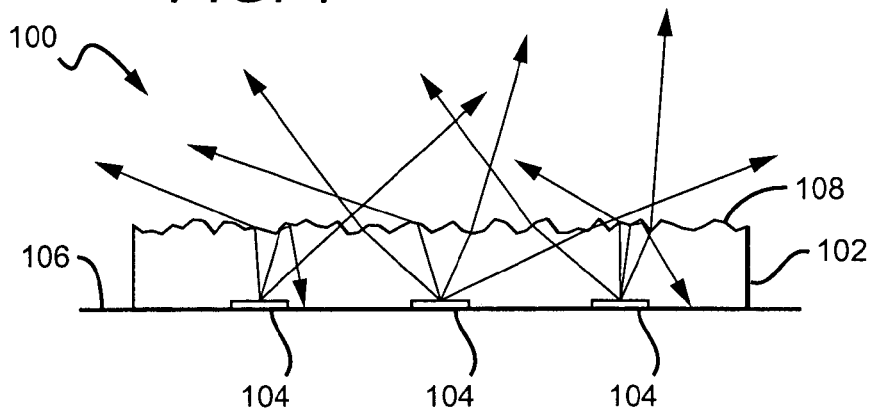


FIG. 2

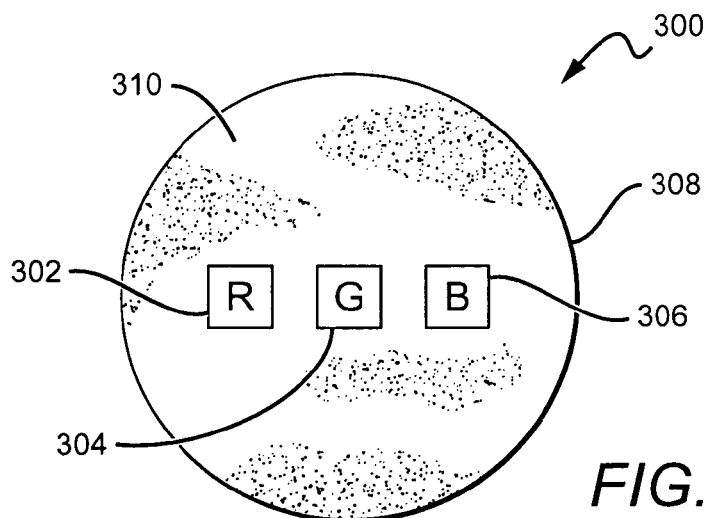
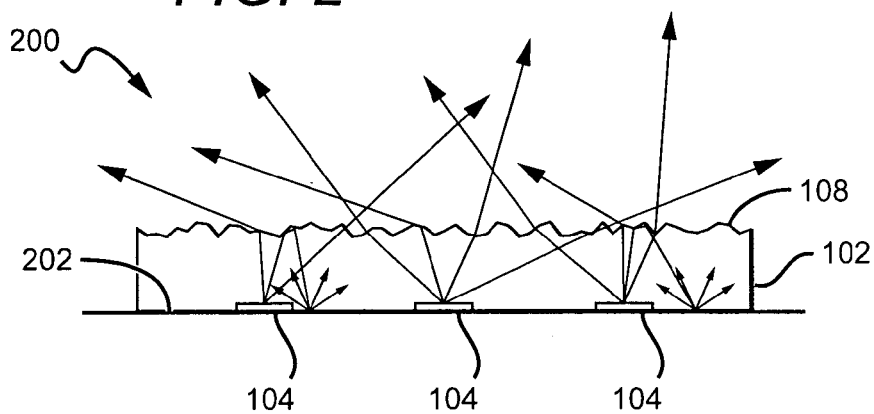


FIG. 3

FIG. 4

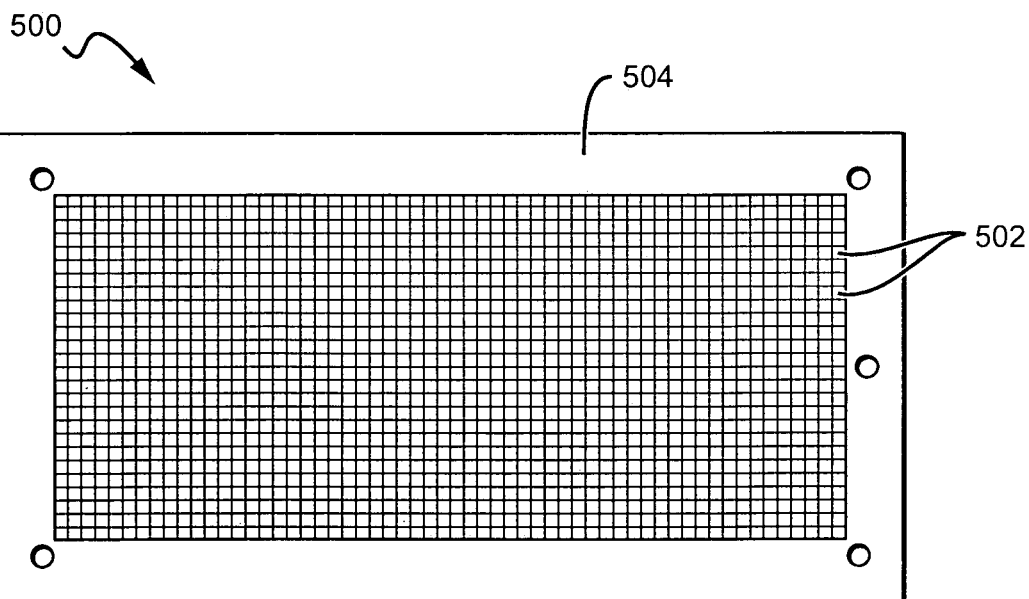
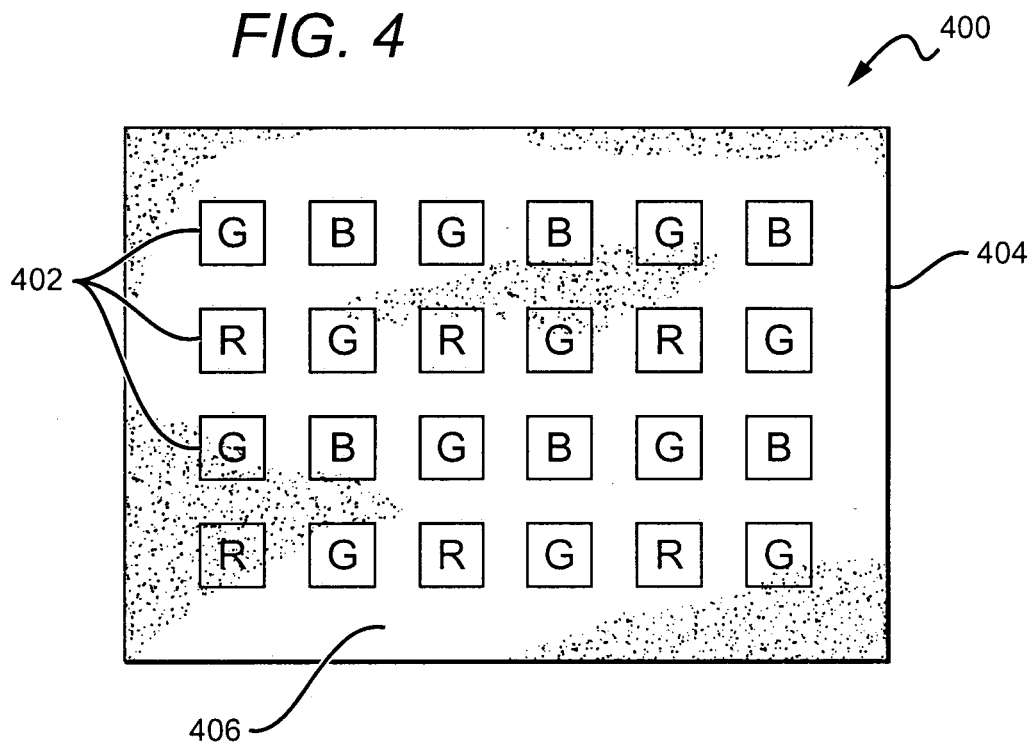


FIG. 5

FIG. 6

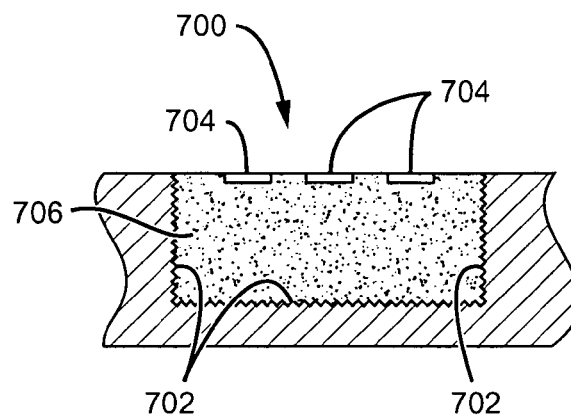
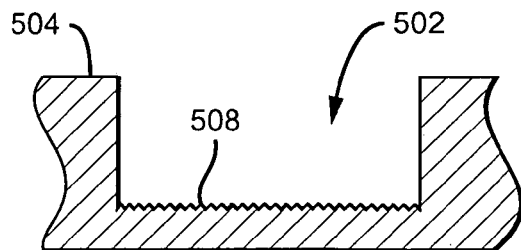


FIG. 7

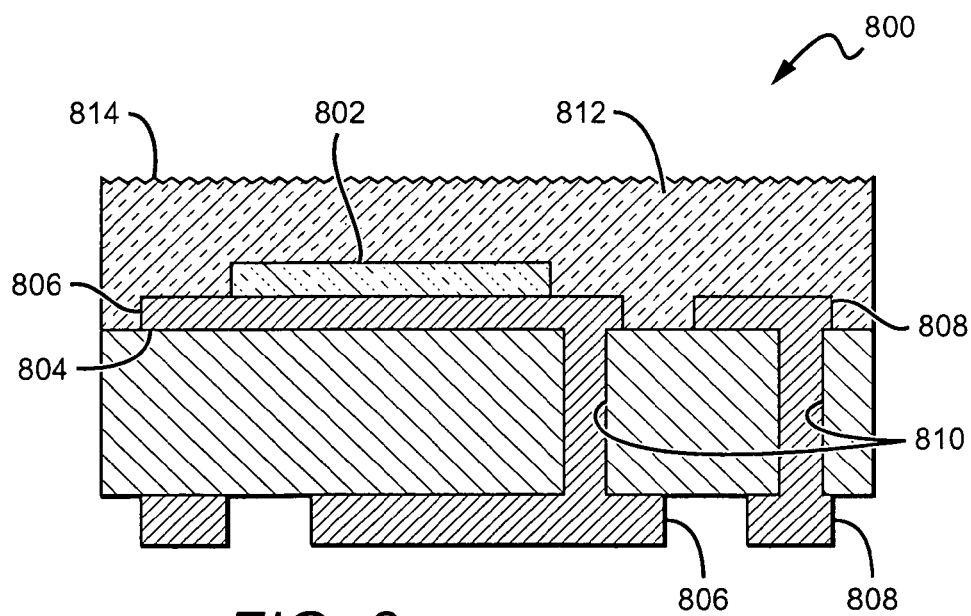


FIG. 8

TEXTURED ENCAPSULANT SURFACE IN LED PACKAGES

BACKGROUND OF THE INVENTION

1. Field of the Invention

The invention relates generally to LED packages and, more particularly, to textured encapsulant surfaces within the LED packages.

2. Description of the Related Art

Light emitting diodes (LED or LEDs) are solid state devices that convert electric energy to light, and generally comprise one or more active layers of semiconductor material sandwiched between oppositely doped layers. Typically, wire bonds are used to apply a bias across the doped layers, injecting holes and electrons into the active layer where they recombine to generate light. Light is emitted from the active layer and from all surfaces of the LED. A typical high efficiency LED comprises an LED chip mounted to an LED package and encapsulated by a transparent medium. The efficient extraction of light from LEDs is a major concern in the fabrication of high efficiency LEDs.

LEDs can be fabricated to emit light in various colors. However, conventional LEDs cannot generate white light from their active layers. Light from a blue emitting LED has been converted to white light by surrounding the LED with a yellow phosphor, polymer or dye, with a typical phosphor being cerium-doped yttrium aluminum garnet (Ce:YAG). [See Nichia Corp. white LED, Part No. NSPW300BS, NSPW312BS, etc.; See also U.S. Pat. No. 5,959,316 to Lowrey, "Multiple Encapsulation of Phosphor-LED Devices"]. The surrounding phosphor material "downconverts" the energy of some of the LED's blue light which increases the wavelength of the light, changing its color to yellow. Some of the blue light passes through the phosphor without being changed while a portion of the light is downconverted to yellow. The LED emits both blue and yellow light, which combine to provide a white light. In another approach light from a violet or ultraviolet emitting LED has been converted to white light by surrounding the LED with multicolor phosphors or dyes.

Various coating processes of LEDs have been considered, including spin coating, spray coating, electrostatic deposition (ESD), and electrophoretic deposition (EPD). Processes such as spin coating or spray coating typically utilize a binder material during the phosphor deposition, while other processes require the addition of a binder immediately following their deposition to stabilize the phosphor particles/powder.

LED packages typically have some type of encapsulant surrounding the LED chip to enhance light extraction from the chip and protect the chip and related contacts structure (e.g., wire bonds) from exposure to physical damage or environmental conditions which could lead to corrosion or degradation. Along with this encapsulant, an optical element such as a simple hemispherical lens is also desired to enhance light extraction from the package and possibly to provide some form of output light beam shaping (control over the angle-dependent emission properties of the lamp). For surface mount packages, which typically require high temperature (200-300° C.) solder reflow processing to attach the LED package to its final fixture, the possible materials typically include silicones and glasses. Silicone lenses are typically molded using injection molding processes, which can place limitations on the properties of the silicone that may be used. Glass lenses are typically formed using a melting process that can limit the possible geometries and

add substantial piece part cost to the final lamp. Typical wire bonded LEDs cannot be encapsulated in molten glass because of the high melting temperature of glass.

A common type of LED packaging where a phosphor is introduced over an LED is known as a "glob-in-a-cup" method. An LED chip resides at the bottom of a cup-like recession, and a phosphor containing material (e.g. phosphor particles distributed in an encapsulant such as silicone or epoxy) is injected into and fills the cup, surrounding and encapsulating the LED. The encapsulant material is then cured to harden it around the LED. This packaging, however, can result in an LED package having significant variation of the color temperature of emitted light at different viewing angles with respect to the package. This color variation can be caused by a number of factors, including the different path lengths that light can travel through the conversion material. This problem can be made worse in packages where the phosphor containing matrix material extends above the "rim" of the cup in which the LED resides, resulting in a predominance of converted light emitted sideways into high viewing angles (e.g., at 90 degrees from the optic axis). The result is that the white light emitted by the LED package becomes non-uniform and can have bands or patches of light having different colors or intensities.

The efficient extraction of light from LEDs is a major concern in the fabrication of high efficiency LEDs. For conventional LEDs with a single out-coupling surface, the external quantum efficiency is limited by total internal reflection (TIR) of light from the LED's emission region that passes through the substrate. TIR can be caused by the large difference in the refractive index between the LED's semiconductor and surrounding ambient. Some LEDs have relatively low light extraction efficiencies because the high index of refraction of the substrate compared to the index of refraction for the surrounding material, such as epoxy. This difference results in a small escape cone from which light rays from the active area can transmit from the substrate into the epoxy and ultimately escape from the LED package.

Different approaches have been developed to reduce TIR and improve overall light extraction, with one of the more popular being surface texturing. Surface texturing increases the light escape probability by providing a varying surface that allows photons multiple opportunities to find an escape cone. Light that does not find an escape cone continues to experience TIR, and reflects off the textured surface at different angles until it finds an escape cone. The benefits of surface texturing have been discussed in several articles. [See Windisch et al., *Impact of Texture-Enhanced Transmission on High-Efficiency Surface Textured Light Emitting Diodes*, Appl. Phys. Lett., Vol. 79, No. 15, October 2001, Pgs. 2316-2317; Schnitzer et al. *30% External Quantum Efficiency From Surface Textured, Thin Film Light Emitting Diodes*, Appl. Phys. Lett., Vol 64, No. 16, October 1993, Pgs. 2174-2176; Windisch et al. *Light Extraction Mechanisms in High-Efficiency Surface Textured Light Emitting Diodes*, IEEE Journal on Selected Topics in Quantum Electronics, Vol. 8, No. 2, March/April 2002, Pgs. 248-255; Streubel et al. *High Brightness AlGaInP Light Emitting Diodes*, IEEE Journal on Selected Topics in Quantum Electronics, Vol. 8, No. March/April 2002].

U.S. Pat. No. 6,657,236, also assigned to Cree Inc., discloses structures formed on the semiconductor layers for enhancing light extraction in LEDs through the use of internal and external optical elements formed in an array. The optical elements have many different shapes, such as hemispheres and pyramids, and may be located on the

surface of, or within, various layers of the LED. The elements provide surfaces from which light refracts or scatters.

In order to emit light having a specific spectral content, it is known to use LED packages having multiple chips. Often, multiple chips having different colors are used in the same package. For example, a red chip, a green chip and a blue chip can be used in combination to form a white light package (solid state RGB). Other multi-chip combinations are also common, such as the solid state RRGB which comprises one red chip, one blue chip and two green chips per unit. Phosphor conversion layers may be used in conjunction with these multi-chip devices, for example, the phosphor converted RGB which is used for high Color Rendering Index applications. Another known device consists of a phosphor converted white LED and a solid state red chip. Other combinations of phosphor-converted colored chips and solid state chips are also known in a multi-chip LED package.

SUMMARY OF THE INVENTION

One embodiment of a light emitting diode (LED) device comprises the following elements. At least one LED chip is disposed on a mount surface. An encapsulant is disposed proximate to the mount surface such that substantially all of the light emitted from the at least one LED passes through the encapsulant. The encapsulant comprises a textured emission surface that is substantially conformal with the mount surface. The encapsulant reduces the total internal reflection of the emitted light as compared to a similar encapsulant having a non-textured emission surface.

One embodiment of a chip-scale package light emitting diode (LED) device comprises the following elements. A plurality of LEDs is disposed on a mount surface. An encapsulant has an emission surface that is substantially parallel to the mount surface. The emission surface is textured to create a plurality of roughening surface features.

One method of fabricating a light emitting diode (LED) device comprises the following actions. A mount surface is provided. At least one LED chip is disposed on the mount surface. An encapsulant having an emission surface is deposited on the at least one LED chip. The encapsulant is shaped such that the emission surface is textured. The encapsulant is cured.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 shows a cross-sectional view of an embodiment of an LED device.

FIG. 2 shows a cross-sectional view of an embodiment of an LED device.

FIG. 3 shows a top plan view of an LED device having red, green and blue LED chips.

FIG. 4 shows a top plan view of an LED device having several red, green and blue LED chips.

FIG. 5 shows a top plan view of an embodiment of a mold device for simultaneously molding several encapsulants on LED devices.

FIG. 6 shows a cross-sectional view of an embodiment of a cavity in a portion of a mold device.

FIG. 7 shows a cross-sectional view of an embodiment of a cavity in a portion of a mold device.

FIG. 8 shows a cross-sectional view of an embodiment of an LED package device 800.

DETAILED DESCRIPTION OF THE INVENTION

The present invention provides embodiments of an LED device comprising an encapsulant with a textured surface that helps to reduce light loss due to total internal reflection (TIR) while maintaining acceptable color temperature uniformity and color mixing in the output profile. TIR is an optical phenomenon that occurs when a ray of light strikes a medium boundary at an angle that exceeds the critical angle as defined by Snell's Law. The critical angle is a function of the index of refraction differential between the two media. TIR can only occur when light passes from a medium with a higher index of refraction to a medium with a lower index of refraction. If a light ray strikes the medium boundary at an angle greater than the critical angle, the light will reflect back into the medium from which it came rather than escaping as emitted light. The internally reflected light may then be absorbed by materials within the medium or by the medium itself. TIR reduces the extraction efficiency of an LED device.

Encapsulants can be formed into many shapes to achieve various design goals. Some LED packages include a dome-shaped encapsulant disposed over the chip to reduce the TIR of the emitted light. The dome-shaped encapsulant may be designed so that the light rays are incident on the inner surface of the encapsulant at close to right angles at all points of incidence. The geometry of these encapsulants ensures that light almost always strikes the boundary at close to a right angle; thus, the light is rarely reflected back into the encapsulant, yielding higher extraction efficiencies.

However, it is not always desirable to use a dome-shaped encapsulant. For example, in multi-chip arrangements it may not be acceptable to assume that the light is emanating from a point at the center of the mount surface on which the chips are disposed. The chips may be mounted in various positions on the mount surface. In many cases, the chips emit light of different colors. Because of the chip placement on the mount surface, each of the colored beams will have different angular distributions, and the emission spectrum will suffer from poor color uniformity in the output profile. Thus, a dome-shaped encapsulant reduces the effects of TIR but can lead to poor color mixing in multi-chip configurations.

A flat encapsulant, on the other hand, will provide a relatively uniform color distribution in the far field. However, the flat encapsulant will suffer from significant TIR, reducing the extraction efficiency of the device. This is especially true for interfaces having a refractive index differential of greater than 0.4, such as epoxy/air, silicone/air or any transparent plastic/air interface, for example. Embodiments of the present invention comprise an encapsulant having a modified surface to reduce the effects of TIR while maintaining relatively uniform color distribution.

It is understood that when an element such as a layer, region or substrate is referred to as being "on" another element, it can be directly on the other element or intervening elements may also be present. Furthermore, relative terms such as "inner", "outer", "upper", "above", "lower", "beneath", and "below", and similar terms, may be used herein to describe a relationship of one layer or another region. It is understood that these terms are intended to encompass different orientations of the device in addition to the orientation depicted in the figures.

Although the terms first, second, etc. may be used herein to describe various elements, components, regions, layers and/or sections, these elements, components, regions, layers and/or sections should not be limited by these terms. These

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terms are only used to distinguish one element, component, region, layer or section from another region, layer or section. Thus, a first element, component, region, layer or section discussed below could be termed a second element, component, region, layer or section without departing from the teachings of the present invention.

It is noted that the terms “layer” and “layers” are used interchangeably throughout the application. A person of ordinary skill in the art will understand that a single “layer” of material may actually comprise several individual layers of material. Likewise, several “layers” of material may be considered functionally as a single layer. In other words the term “layer” does not denote an homogenous layer of material. A single “layer” may contain various scattering material concentrations and compositions that are localized in sub-layers. These sub-layers may be formed in a single formation step or in multiple steps. Unless specifically stated otherwise, it is not intended to limit the scope of the invention as embodied in the claims by describing an element as comprising a “layer” or “layers” of material.

Embodiments of the invention are described herein with reference to cross-sectional view illustrations that are schematic illustrations of idealized embodiments of the invention. As such, variations from the shapes of the illustrations as a result, for example, of manufacturing techniques and/or tolerances are expected. Embodiments of the invention should not be construed as limited to the particular shapes of the regions or particles illustrated herein but are to include deviations in shapes that result, for example, from manufacturing. A region illustrated or described as rectangular, for example, will typically have rounded or curved features due to normal manufacturing tolerances. Thus, the regions illustrated in the figures are schematic in nature and their shapes are not intended to illustrate the precise shape of a region or particle and are not intended to limit the scope of the invention.

FIG. 1 shows a cross-sectional view of an LED device 100 according to an embodiment of the present invention. The device 100 comprises an encapsulant element 102 that is disposed above the light sources 104 such that substantially all of the light emitted from the sources 104 has to pass through it.

The encapsulant 102 may be very thin such that it barely covers the bond wires, if they are used, or it can be much thicker. An acceptable range for the thickness of the encapsulant is 70-200 micrometers. The ray paths of the emitted light are shown by the arrows in the figures. In this embodiment, the encapsulant 102 is disposed such that the encapsulant 102 and the light sources 104 are mounted to a common surface 106, such as a substrate, for example.

The encapsulant 102 may comprise any structure that is disposed above the sources 104 as described above, and in one embodiment the encapsulant comprises a lens used alone or in combination with other bonding materials to mount the lens over the source. The encapsulant can be transparent, translucent, or luminescent, for example, and can be loaded with wavelength conversion materials, such as phosphors. The encapsulant 102 can be made of silicone, epoxy, glass, plastic or other materials and may perform functions such as beam shaping, collimating, and focusing, etc. The encapsulant 102 may be formed in place over the source as with a mold, or it may be fabricated separately and then subsequently attached to the light source by an adhesive epoxy, for example.

One way to redirect light is to modify selected areas of the encapsulant surface 108. The surface 108 can be modified by several known additive and subtractive methods such as

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etching or grinding, for example, as discussed in detail below. A textured surface can be produced by any known mass-production method such as molding or casting where the mold surface impresses the texturing contours directly on the encapsulant during the process. Light approaching a modified portion of the encapsulant surface 108 (as opposed to an unmodified portion) has a higher probability of being redirected and exiting the encapsulant 102 at another point. If the light does not exit on the first pass, it may be reflected within the encapsulant 102 and come in contact with the surface 108 again and be emitted on a second pass. The modified surface 108 also has the effect of randomizing the emission angle of the emitted light. As shown in FIG. 1, the irregular features of the modified surface 108 redirect the light, causing it to deviate from the path it originally took from the source 104. Because the light is disassociated from its original path, the output profile exhibits a more uniform color distribution.

The modified surface can be formed by additive or subtractive processes and may have features with many different shapes. For example, material may be added to the encapsulant surface to create irregular structures that will scatter the light. The added material may be deposited by many known processes such as chemical vapor deposition. A textured surface can also be fashioned using a post-additive process such as chemical etching, machining by single or multiple-point tools, sand-blasting, etc. Another method for modifying the surface is to remove portions of the encapsulant material leaving behind small holes and trenches. Many different known subtractive methods are available such as etching, for example. The modified surface can have patterned or random features. In the former case, it may be created by machining to give the surface a specifically patterned texture. If the surface is machined, an acceptable range of the average peak-to-valley size of the surface features would be from 50-200 micrometers. If the surface features are random, they may be formed by several processes including electro-discharge machining. Surface modifications may result in surface features that have several shapes including, spheres or hemispheres, triangles, skewed triangles, pyramids, truncated pyramids and many other shapes. There are many other known methods of modifying an encapsulant surface.

FIG. 2 is a cross-sectional illustration of an LED device 200 according to an embodiment of the present invention. The device 200 functions similarly as the device 100 and shares several common elements. The device 200 comprises a reflective surface 202. As discussed above the modified surface 108 also helps reduce TIR on light interacting with the surface 108 on second, third, etc., passes. The reflective surface 202 can comprise a diffuse reflector, a specular reflector, or a combination of the two. The reflective surface 202 should be highly reflective in the wavelength ranges emitted by the sources 104 for high efficiency. The reflective surface 202 can be specular or textured and can have scattering properties.

FIG. 3 is a top view of an LED device 300. The LED device 300 comprises a red chip 302, a green chip 304, and a blue chip 306, all of which are disposed on a mount surface. This embodiment shows one possible arrangement of chips in an RGB configuration. RGB chips may be arranged in many ways and are not restricted to any particular pattern. Because the chips 302, 304, 306 are not centered on the mount surface, the various colors of light are not emitted into the encapsulant 308 uniformly. For example, if the encapsulant 308 is flat (as shown), the light emitted from the red chip 302 will be incident on the portion

of the encapsulant **308** directly above the red chip **302** at angles close to 90°. Whereas light emitted from the blue chip **306** will be incident on that same portion of the encapsulant **308** at much lower angles. Thus, if a randomization element is not used, more red light will be emitted in the space

directly above the red chip **302** than blue light, leading to a poor color temperature uniformity in the output profile. The LED device **300** comprises an encapsulant **308** having a textured surface **310**. The encapsulant **308** is disposed such that the light emitted from the chips **302**, **304**, **306** passes through the encapsulant **308** and into the ambient space. The textured surface **310** improves extraction efficiency by reducing TIR and improves color temperature uniformity by randomizing the emission angle of light rays emitted from the various chips **302**, **304**, **306**. Although this particular embodiment features an RGB chip configuration on a circular mount surface, it is understood that many different colored LED combinations may be used on many different shapes of mount surfaces.

FIG. **4** is a top plan view of another LED device **400**. The device **400** includes several colored LED chips **402** disposed on a rectangular mount surface. This particular embodiment features an RRGB arrangement of red, green and blue emitters. As discussed above many different color and spatial arrangements may be used to achieve a particular output profile. An encapsulant **404** is disposed over the chips **402** so that most of the light emitted passes through the encapsulant **404** into the ambient space. The encapsulant **404** comprises a textured surface **406** that randomizes the emission angle of light rays emitted from the various chips **402**, improving the color temperature uniformity of the device **400**. The textured surface **406** also reduces TIR. As shown, many chips can be mounted and covered with single encapsulant layer. This particular embodiment features **24** chips. More or fewer chips may be used according to design needs. The encapsulant can be formed or deposited on the mount surface and the chips **402** using a mold, for example.

FIG. **5** shows a top plan view of a mold device **500** used to shape several encapsulants simultaneously for inclusion in a chip-scale package LED. The mold device **500** comprises several cavities **502** arranged in an array on a mold base **504**. The width of the cavities may be only slightly larger than the width of a single chip, or the cavities **504** may be wider to accommodate multi-chip arrays and other elements that will be covered by the encapsulant. A plurality of bore holes **506** can be used to mount the mold base **504** to a surface to steady the device during processing. Several LED devices (not shown) can be positioned so that each device is located within or adjacent to the space created by each cavity **502**. For example, if the mold device is positioned over the LED devices, each of the devices should be located beneath one of the cavities **502**. An encapsulant material can be injected into each of the cavities **502** prior to placing the mold device **500** over the LEDs for processing, or alternatively, the encapsulant material can be injected after the devices are in position as through fill hole (not shown). The encapsulant material may be cured at high temperatures using thermoset plastics, such as epoxies, silicones or hybrids of both.

Each of the cavities **502** has at least one irregular surface. Referring to FIG. **6**, cavity **502** has an irregular bottom surface **508**. The irregular bottom surface **508** has contours that shape the encapsulant material as it is hardened around the LED devices. When the encapsulant has been cured, the devices can be removed. The resulting encapsulant will have a textured top surface. The mold device **500** allows for encapsulants to be placed onto several LEDs and cured

simultaneously. Each encapsulant formed using the mold will have a textured top surface. The inner surfaces of the cavities **502** can be roughened according to particular specifications to achieve a particular textured surface on the resulting molded encapsulants. The surface may have average peak-to-valley distances ranging from a few micrometers to several hundred micrometers, with an acceptable range being 1-200 micrometers.

FIG. **7** shows a cavity **700** that comprises multiple irregular surfaces **702**. Multiple LED chips **704** can be enveloped under a common encapsulant as shown. The LED chips **704** are shown disposed adjacent to the cavity **700**. The encapsulant material **706** is injected into the cavity **700** and cured. The resulting encapsulant has three textured surfaces that mirror the irregular surfaces **702** of the cavity **700**. In some embodiments, the various surfaces may have different finishes. As discussed above the roughened encapsulant helps to improve light extraction and color temperature uniformity of the packaged LED devices.

FIG. **8** is a cross-sectional view of an embodiment of an LED package device **800**. An LED chip **802** is disposed on a mount surface **804** which can be part of a package. First and second electrodes **806**, **808** are arranged to provide a bias to the LED chip **802**. In this particular embodiment, both of the electrodes **806**, **808** are accessible from the side of the device **800** which is opposite from the primary emission surface. Vias **810** provide a path for current to travel from the bottom side of the mount surface **804** up to the LED chip **802**. The second electrode **808** can be connected to the LED chip **802** with a wire bond (not shown).

An encapsulant **812** is disposed over the LED chip **802**, the mount surface **804**, and the electrodes **806**, **808**. The encapsulant **812** is flat, providing a primary emission surface **814** that is parallel to the mount surface **804**. Some light may escape from encapsulant surfaces other than the primary emission surface **814** such as the side surfaces. In other embodiments these surfaces can also be modified by roughening. A mold similar to the one shown in FIG. **6** may be used to deposit the encapsulant **812** onto a chip package. Using a mold allows for many LED device packages to be encapsulated simultaneously. The devices can then be singulated by dicing or by other separation techniques known in the art. In other embodiments, an encapsulant having an emission surface that is conformal with all of the chip package components may be deposited over the device.

Light is emitted from the LED chip **802** and interacts with the encapsulant **812**. The primary emission surface **814** can be modified to improve light extraction and color temperature uniformity as discussed in detail above. If manufactured using a mold, for example, the surface **814** may comprise roughening features corresponding to the internal surfaces of the mold. The mount surface **804** and electrodes **806**, **808** may comprise a reflective material (e.g., diffuse, specular, or a combination of both) so that light that is internally reflected is redirected back towards surface **814** for a second pass at emission. The LED package device **800** represents one of many packages that may be manufactured to include a flat encapsulant.

Although the present invention has been described in detail with reference to certain preferred configurations thereof, other versions are possible. Therefore, the spirit and scope of the invention should not be limited to the versions described above.

We claim:

1. A light emitting diode (LED) device, comprising: first and second electrodes, said first electrode comprising a first top surface, said first and second electrodes are

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accessible for electrical connection from a side of the LED device opposite said primary emission surface;
 a substrate comprising one or more vias, wherein said one or more vias provide a path for current to travel from said side of the LED device opposite said primary emission surface;
 a plurality of LED chips entirely on said first top surface; and
 an encapsulant disposed proximate to said mount surface, said encapsulant comprising a textured primary emission surface and at least one side emission surface;
 wherein all of said first top surface is covered by said encapsulant and wherein said plurality of LED chips and said encapsulant are configured such that light can be emitted from said LED device from said at least one side emission surface;
 wherein all of a top surface of said substrate adjacent to said encapsulant is covered by at least a portion of said encapsulant such that said encapsulant extends to the edges of said top surface of said substrate.

2. The LED device of claim 1, wherein said plurality of LED chips comprises LED chips emitting at least two different spectra of light.

3. The LED device of claim 2, said plurality of LED chips comprising LED chips emitting a red spectrum, LED chips emitting a green spectrum, and LED chips emitting a blue spectrum.

4. The LED device of claim 2, said plurality of LED chips comprising LED chips emitting a red spectrum and LED chips emitting a white spectrum.

5. The LED device of claim 2, said plurality of LED chips comprising LED chips emitting a blue spectrum and LED chips emitting a yellow spectrum.

6. The LED device of claim 2, wherein said plurality of LED chips is arranged in a substantially linear array.

7. The LED device of claim 1, wherein said first top surface comprises a reflective material.

8. The LED device of claim 7, wherein said reflective material forms a specular reflector.

9. The LED device of claim 7, wherein said reflective material forms a diffuse reflector.

10. The LED device of claim 7, wherein said reflective material forms a combination of specular and diffuse reflectors.

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11. The LED device of claim 7, wherein said reflective material has light scattering properties.

12. The LED device of claim 1, wherein said textured primary emission surface comprises additive features.

13. The LED device of claim 1, wherein said textured primary emission surface comprises subtractive features.

14. The LED device of claim 1, wherein said encapsulant forms an interface with an ambient medium such that that index of refraction differential at said interface is at least 0.4.

15. The LED device of claim 1, wherein said textured primary emission surface has an average peak-to-valley roughness of 1-50 micrometers.

16. The LED device of claim 15, wherein said textured primary emission surface has an average peak-to-valley roughness ranging from 50-200 micrometers.

17. The LED device of claim 1, wherein said encapsulant comprises a wavelength conversion material.

18. The LED device of claim 1, wherein said encapsulant comprises phosphors.

19. The LED device of claim 1, wherein said encapsulant adheres directly to said LED chips and said first top surface.

20. The LED device of claim 1, wherein said encapsulant is attached to said LED chips with an adhesive epoxy.

21. The LED device of claim 1, wherein said textured emission surface has a patterned texture.

22. The LED device of claim 1, wherein said textured emission surface has a random texture.

23. The LED device of claim 1, said at least one side emission surface comprising a textured surface.

24. The LED device of claim 23, wherein said primary emission surface and said at least one side emission surface have different textures.

25. The LED device of claim 1, wherein said encapsulant has a thickness ranging from 70-200 micrometers.

26. The LED device of claim 1, wherein said first top surface is reflective.

27. The LED device of claim 1, wherein said second electrode comprises a second top surface; and wherein all of said second top surface is covered by said encapsulant.

28. The LED device of claim 27, wherein said first and second top surfaces are reflective.

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